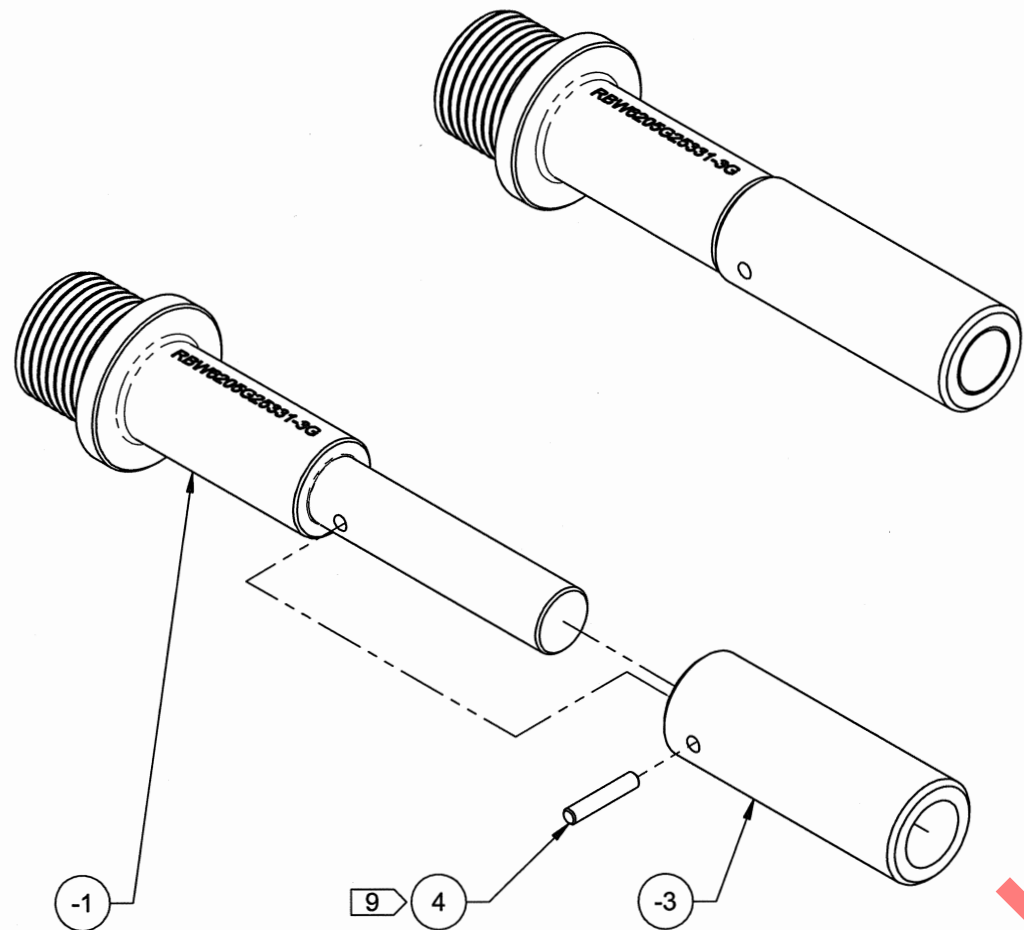
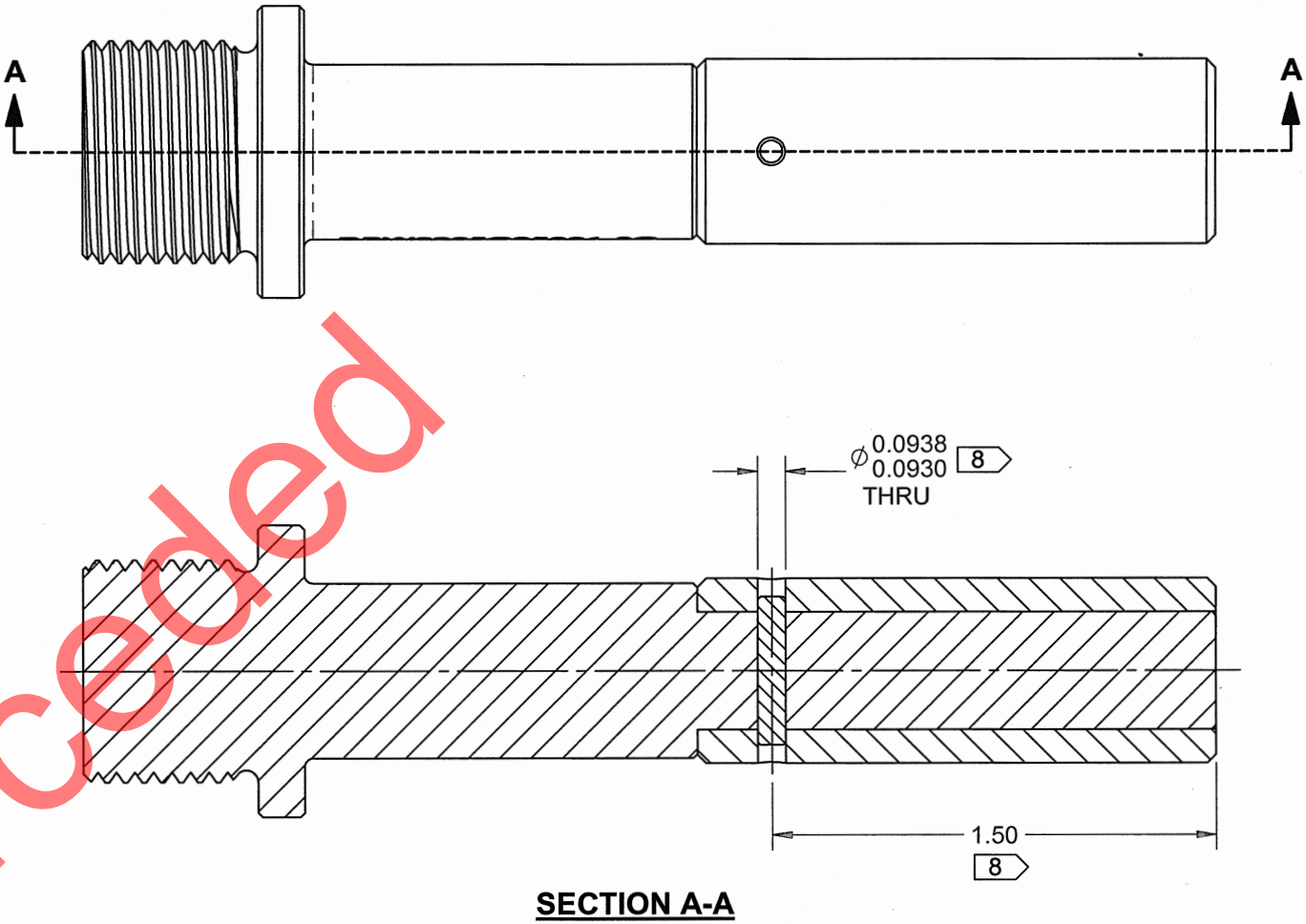


ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6205G25331-3G-1	PULLER
-3	1	RBW6205G25331-3G-3	PROTECTOR
4	1	MS16555-320	PHOSPHATE PLATED STEEL DOWEL PIN 3/32" DIA. X 1/2" LG.



RBW6205G25331-3G HUB PULLER ASSY

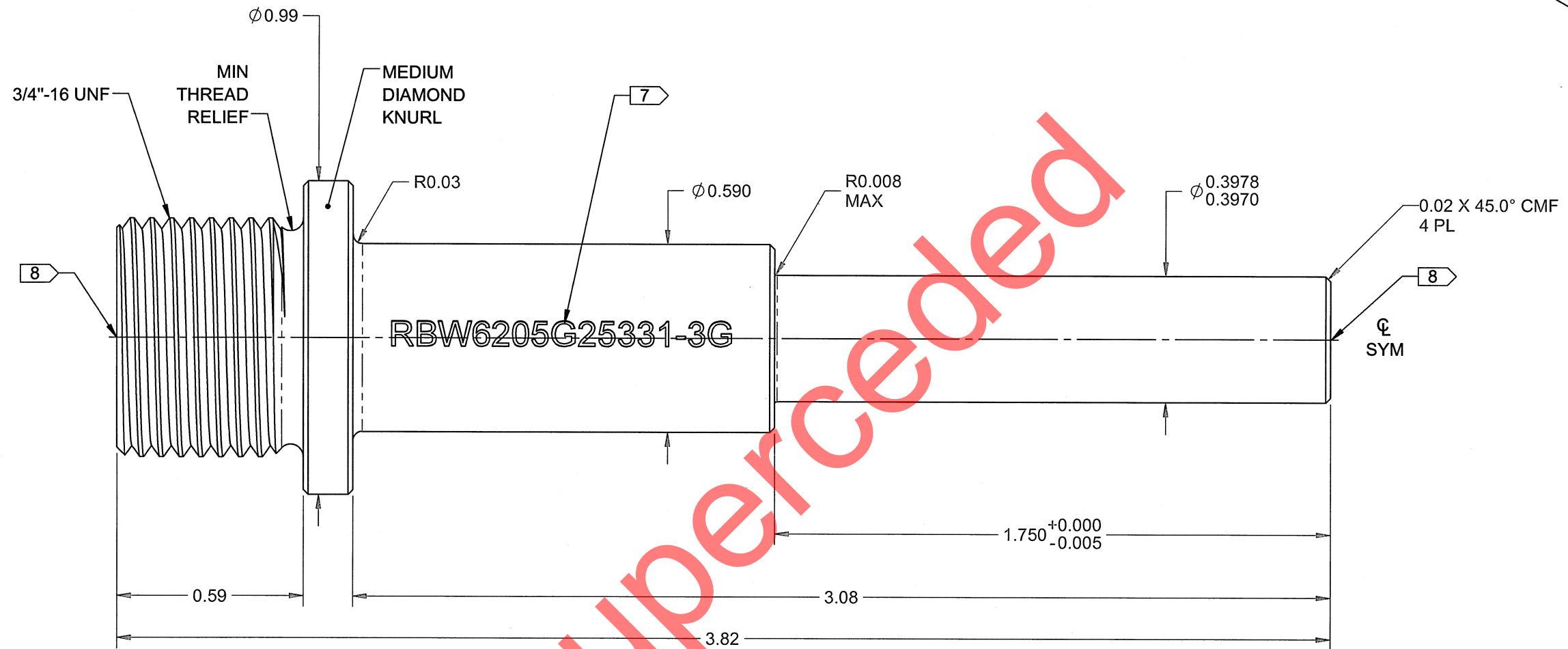


SECTION A-A

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) TRANSFER DRILL HOLE THROUGH ITEMS -3 AND -1 AS SHOWN
 - 9) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 4 WITH ITEM -3 AND ITEM -1, AND REMOVE EXCESS
 - 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

UNDER REVIEW
ECR: ECR 328

FOR OLDER REV'S SEE PREVIOUS PDFs TEMPLATE UPDATED PER DART HBY STANDARDS TRANSFER DRILL FOR DOWEL PIN ADDED ON SHEET 1 ITEM 5 McMaster#90145A439 CHANGED FOR ITEM 4 MS16555-320 ITEM -1 DIMENSION R0.03 ADDED, ENGRAVING ADDED, DIMENSION .275 +.005/-0 REMOVED, DIMENSION Ø.0936/0.0932 THRU ALL REMOVED, DIMENSION 1.773 +.010/-0 CHANGED FOR 1.750 +0/-0.005, DIMENSION Ø.393/0.392 CHANGED FOR Ø.0.3978/0.3970, DIMENSION R0.008 MAX ADDED, CENTER DRILL ADDED, DIMENSION 1.31 REMOVED, DIMENSION 3.08 ADDED, MATERIAL 17-4 PH FINISH PASSIVATE CHANGED FOR 4140 (28-32 RC) FINISH BLACK OXIDE ITEM -3 DIMENSION Ø.399/0.394 CHANGED FOR Ø.0.3970/0.3955, DIMENSION Ø.624 +/- .002 CHANGED FOR Ø.0.623/0.620, DIMENSION 1.766 +0/-0.010 CHANGED FOR 1.750 +0.010/-0, DIMENSION .03 X 45° CMF 4 PL CHANGED FOR 0.03 X 45.0° CMF 2 PL		19-899	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RBW6205G25331-3G TITLE HUB PULLER ASSY SCALE NTS REV. C SHEET 1 OF 3 COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	VM		
CHECKED	KPT		
MFG. APPR.	JFC		
APPROVED	WJ		
DATE	2019-09-11		



RBW6205G25331-3G-1 PULLER

UNDER REVIEW
ECR: ECR 328

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RBW6205G25331-3G", AS SHOWN
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. C
MFG. APPR.	JFC	RBW6205G25331-3G	SHEET 2 OF 3
APPROVED	WJP	TITLE	SCALE
		HUB PULLER ASSY	NTS
DATE	2019-09-11	COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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D

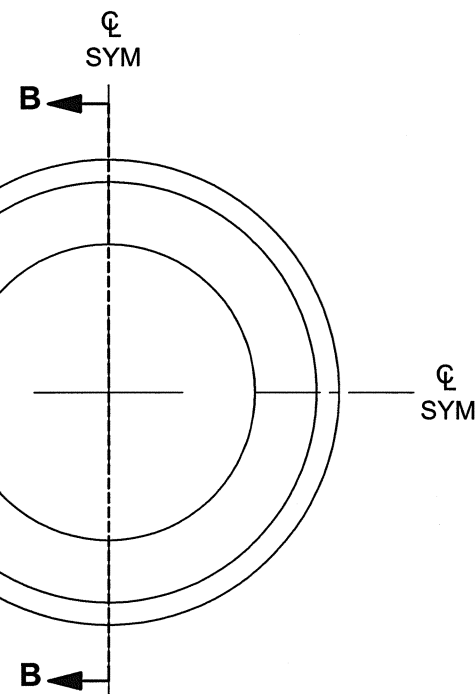
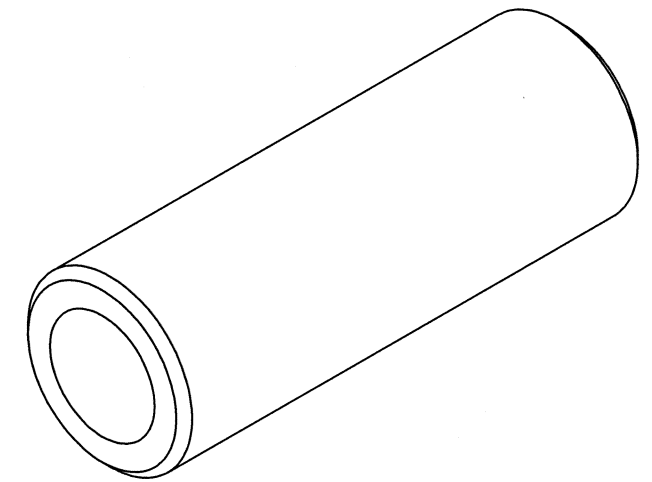
C

B

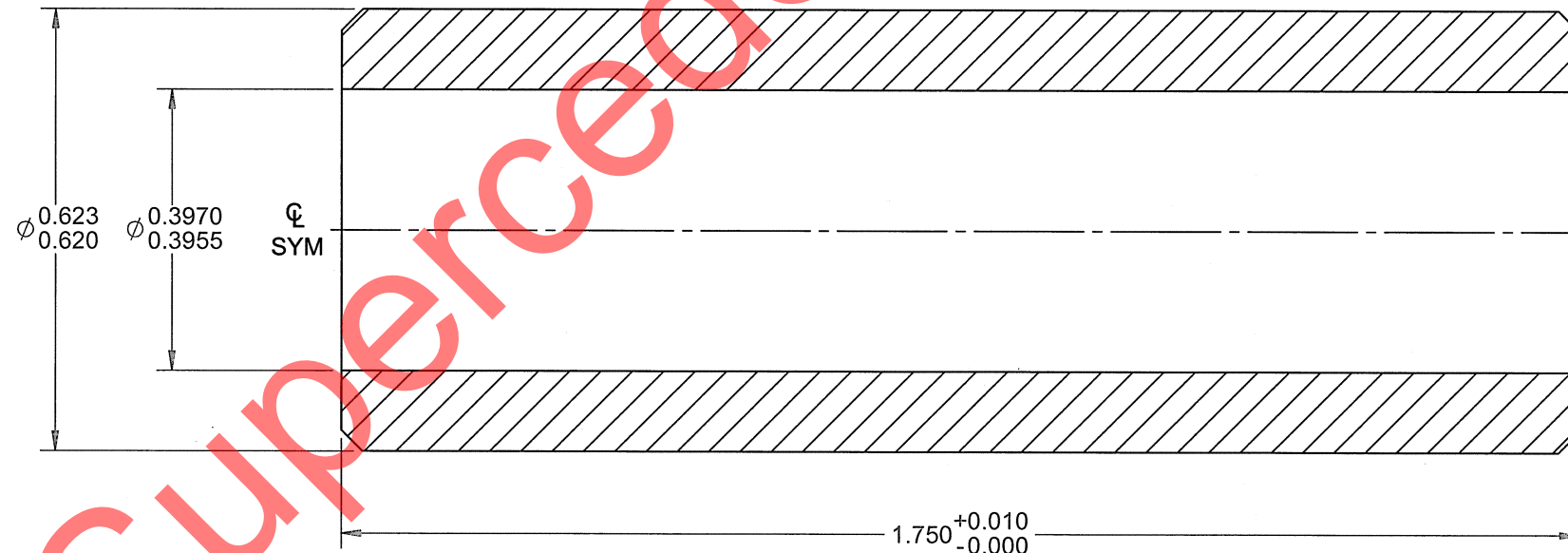
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B



RBW6205G25331-3G-3 PROTECTOR



SECTION B-B

UNDER REVIEW
ECR: ECR 328

NOTES:

- 1) MATERIAL: WHITE DELRIN / ACETAL ASTM D6100
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. C
MFG. APPR.	JFC	RBW6205G25331-3G	SHEET 3 OF 3
APPROVED		TITLE	SCALE
		HUB PULLER ASSY	NTS
DATE	2019-09-11	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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